

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER. PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. CRIMP, SIZE, TYPE. WIRE 1.60 mm [.063], INSUL 2.30 mm [.091]. APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: Molex TERMINAL, Molex CRIMP SPECIFICATION. WIRE STRIP LENGTH, INSULATION DIAMETER RANGE.

TERMINALS APPLIED. Table with columns: TE TERMINAL, Molex TERMINAL, TE TERMINAL, Molex TERMINAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY.
ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62 & 180.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

TERMINAL DATA: Molex TERMINAL, Molex CRIMP SPECIFICATION. WIRE STRIP LENGTH, INSULATION DIAMETER RANGE.

TERMINALS APPLIED. Table with columns: TE TERMINAL, Molex TERMINAL, TE TERMINAL, Molex TERMINAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY.
SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING.
WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.78.
THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
CUT TO LENGTH AT ASSEMBLY

Table with columns: PART NO, DESCRIPTION, ITEM NO. Includes parts like APPLICATOR SHIM PACK, O-RING, PUSH ROD, BUSHING, FEED CAM, DETENT PIN, SPRING, RAM, AMP STYLE, SIDE FEED, NON-ADJ.

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

REVISIONS. SET UP GAUGE 2119599-1, LOC A, DIST 66. Includes columns for P, LTR, DESCRIPTION, DATE, DWN, APVD.

Main assembly table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Lists various components like CAM, SNAIL, INSULATION ADJUSTMENT, WASHER, WAVE SPRING, RETAINER, INSULATION DIAL, etc.

TE Connectivity logo and product information: Ocean Side Feed Applicator. Includes dimensions, tolerances, material, weight, and drawing details.

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

### FEED TYPE MECHANICAL



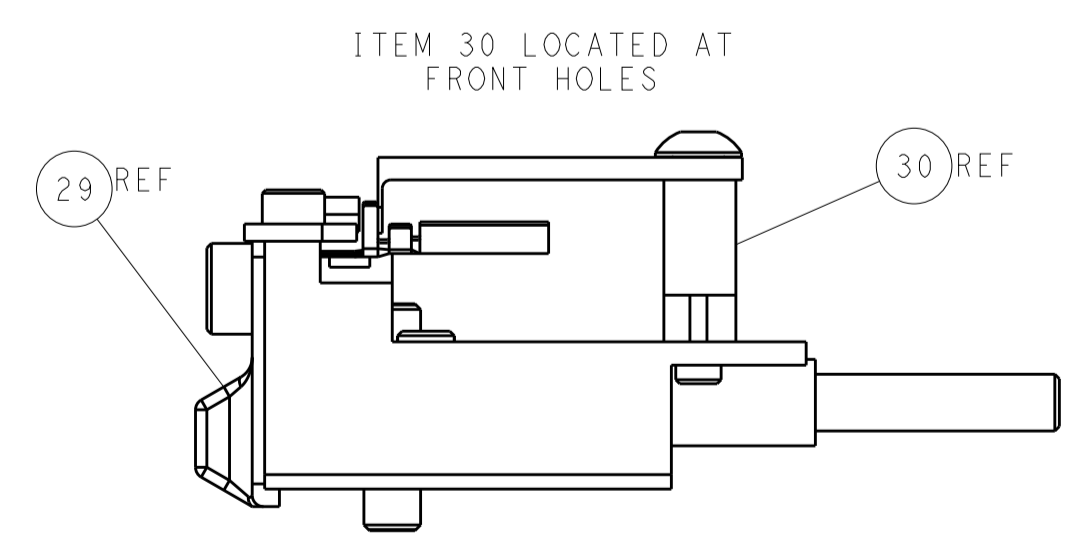
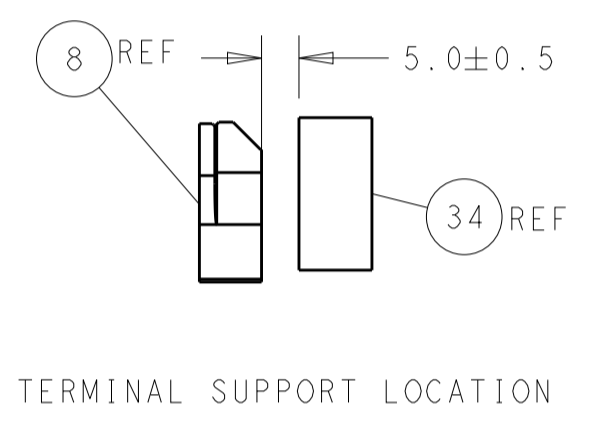
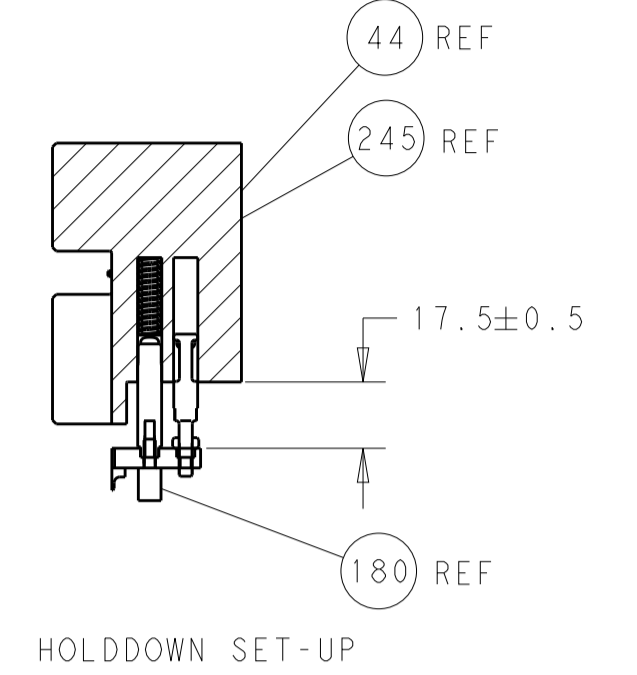
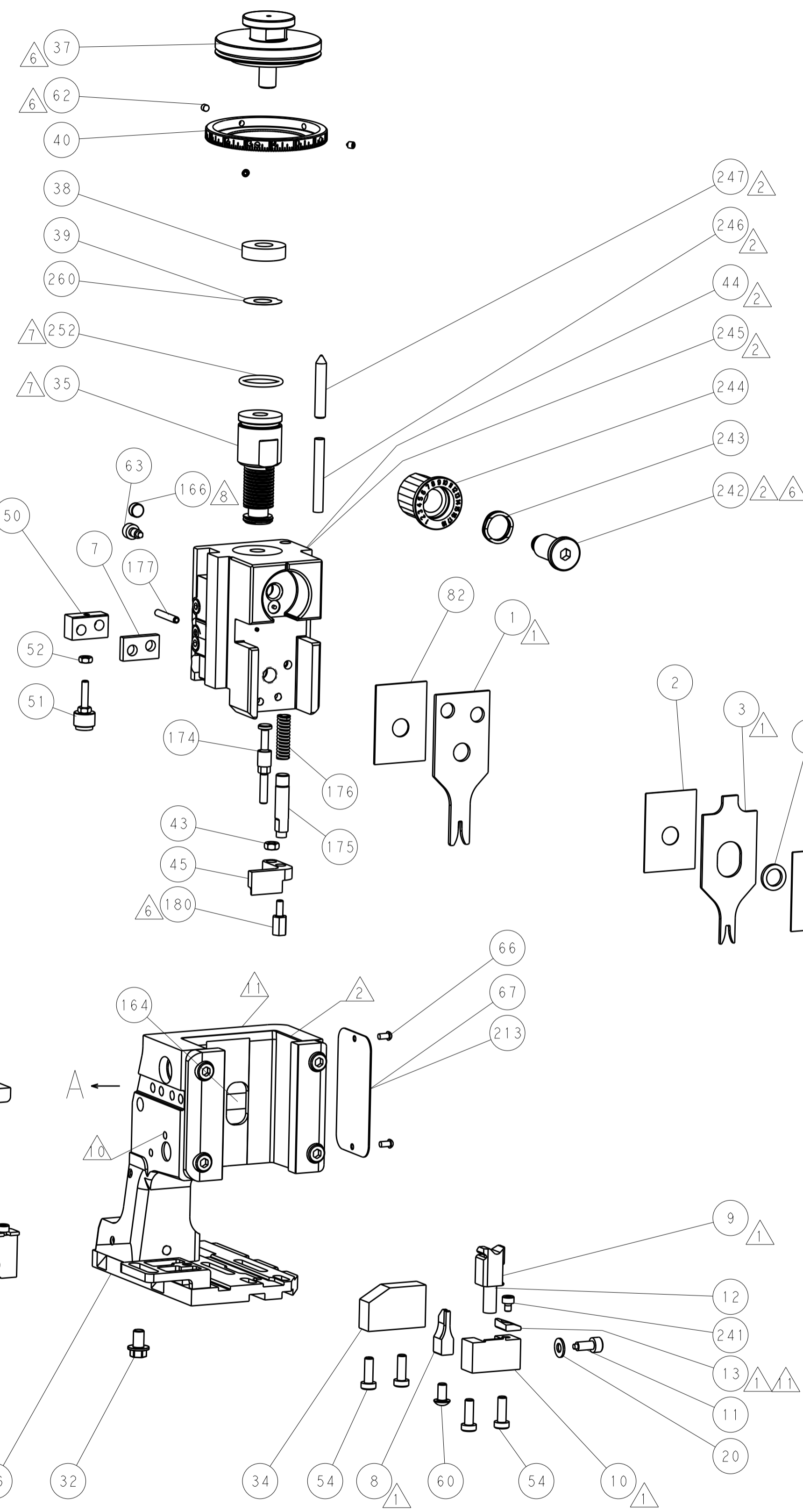
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 17DEC2014		TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 17DEC2014	Harrisburg, PA 17105-3608		
	1 PLC	±		APVD: G. BAILEY 17DEC2014	NAME: Ocean Side Feed		
	2 PLC	±			Applicator		
	3 PLC	±			SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO		
	4 PLC	±			A1 00779 C=2266604		
	ANGLES	±			SCALE: 1:2 SHEET 2 OF 4 REV A1		
MATERIAL:	FINISH:	WEIGHT:	CUSTOMER DRAWING:				

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1
	2-2266604-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2266604-5	1901094-3	1-1752354-9	2168400-6 (QUANTITY 2)
	2-2266604-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2266604-4	-	-	-
	2-2266604-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	2-2266604-7	A	FINE CRIMP HEIGHT ADJUST	NONE	SERVO LATCH PLATE	2119951-1	-	8-2266604-5	1901094-3	1-1752354-9	2168400-6 (QUANTITY 2)
	7-2266604-7	A	CRIMP TOOLING KIT	-	SMART APPLICATOR	2161326-1	-	8-2266604-4	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	2.30 mm [.091]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: Molex TERMINAL Molex CRIMP SPECIFICATION	
TERMINAL NAME: Terminal, MinFit	
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]	INSULATION DIAMETER RANGE $\phi$ 1.90-2.30 mm [.075-.091 IN]
TERMINAL APPLICATION SPECIFICATION 63901-5600 Rev D	

TE TERMINAL	Molex TERMINAL	TE TERMINAL	Molex TERMINAL
286603-1	39-00-0038	2-286603-7	44485-1211
286603-2	39-00-0055	2-286603-8	44485-1311
286603-3	39-00-0207	2-286603-9	44485-1411
286603-4	39-00-0163	286611-1	39-00-0040
286603-5	39-00-0059	286611-2	39-00-0061
286603-6	39-00-0153	286611-3	39-00-0053
286603-7	39-00-0181	286611-4	39-00-0120
286603-8	39-00-0213	286611-5	39-00-0126
1-286603-1	39-00-0114	286611-6	39-00-0219
1-286603-2	39-00-0428	286611-8	39-00-0411
1-286603-3	39-00-0419	286611-9	39-00-0430
1-286603-4	39-00-0425	1-286611-1	39-00-0121
1-286603-5	39-00-0436	1-286611-2	39-00-0420
1-286603-6	39-00-0440	1-286611-3	39-00-0437
1-286603-7	39-00-0073	1-286611-4	39-00-0426
1-286603-8	39-00-0108	1-286611-6	39-00-0075
1-286603-9	39-00-0169	1-286611-7	39-00-0427
2-286603-0	39-00-0175	1-286611-8	40-13-0853
2-286603-1	39-00-0194	2-286611-0	30490-1002
2-286603-2	39-00-0200	2-286611-1	30490-2002
2-286603-3	39-00-0405	2-286611-2	40-01-0853
2-286603-4	39-00-0407	2-286611-3	98-00-0174
2-286603-5	39-00-0410	2-286611-4	30490-0002
2-286603-6	40-13-0851		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG or 0.80mm <sup>2</sup>	1.02+/-0.05 [.040+/- .002]	6.7
20 AWG or 0.50mm <sup>2</sup>	0.995+/-0.045 [.039+/- .002]	6.8
22 AWG or 0.35mm <sup>2</sup>	0.895+/-0.045 [.035+/- .002]	7.8
24 AWG or 0.20mm <sup>2</sup>	0.83+/-0.04 [.033+/- .002]	8.4

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266604-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266604-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266604-5
- ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

TERMINAL DATA: Molex TERMINAL Molex CRIMP SPECIFICATION	
TERMINAL NAME: Terminal, MiniFit	
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]	INSULATION DIAMETER RANGE $\phi$ 1.90-2.30 mm [.075-.091 IN]
TERMINAL APPLICATION SPECIFICATION 63901-5600 Rev D	

TE TERMINAL	Molex TERMINAL	TE TERMINAL	Molex TERMINAL
286603-9	44476-1111	2113022-7	46012-1141
2-286603-7	44476-1211	2113022-8	46012-1211
286611-7	44478-1111	2113022-9	46012-1241
1-286611-9	44478-1211	1-2113022-0	46083-1121
2113022-1	45750-1211	1-2113022-1	46083-1211
2113022-2	45750-1111	1-2113022-2	46083-1221
2113022-3	46012-1111	1-2113022-3	46134-1111
2113022-4	46018-1541	1-2113022-4	46134-1121
2113022-5	46083-1111	1-2113022-5	46134-1211
2113022-6	46098-1541	1-2113022-6	46134-1221

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG or 0.80mm <sup>2</sup>	1.02+/-0.05 [.040+/- .002]	6.7
20 AWG or 0.50mm <sup>2</sup>	0.995+/-0.045 [.039+/- .002]	6.8

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

CUT TO LENGTH AT ASSEMBLY

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	#	DATE	BY	APPD
			-	SEE SHEET 1	-	-

	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	1	1-1752354-9	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
-	-	-	1	-	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	1	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	-	REF	-	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	3	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	2	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	45
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	43
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	1752356-9	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	7-1803054-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	3-240641-0	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	9-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
	1	1	1	1	1	8-1633738-5	CRIMPER, WIRE	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO	

**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CUSTOMER DRAWING	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT		SCALE	SHEET 3 OF 4

**STE** TE Connectivity  
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator

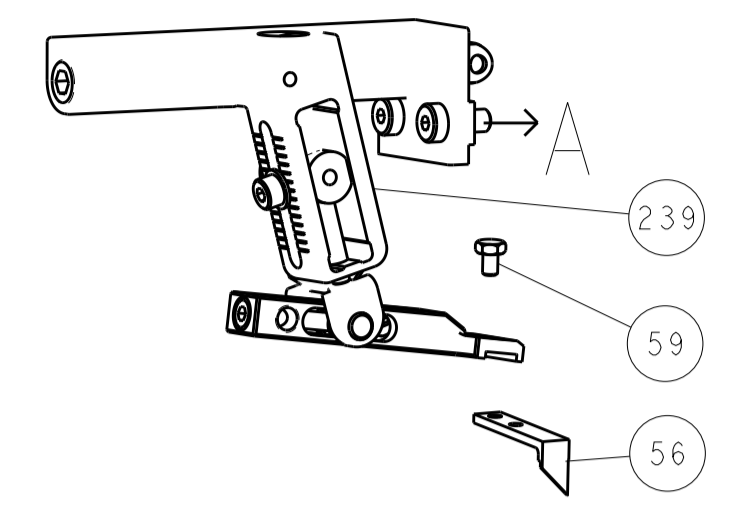
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CUSTOMER DRAWING

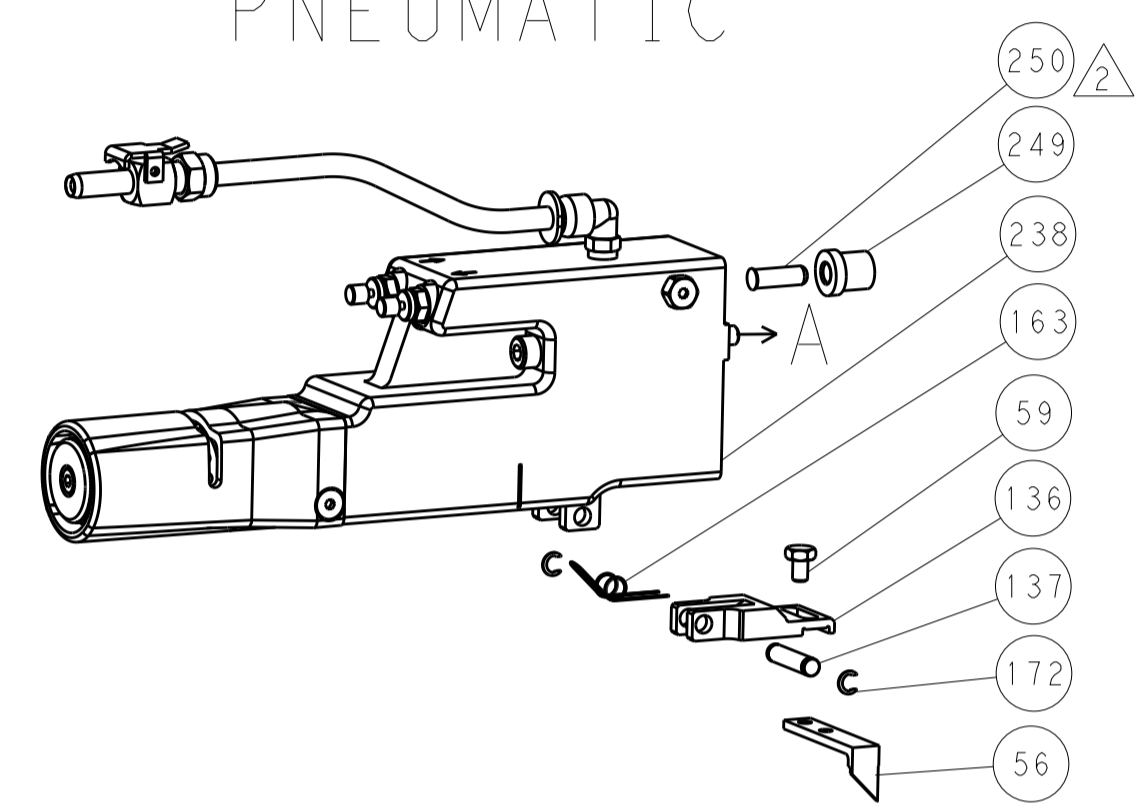


LOC	DIST	REV	DATE	BY	APPD
A	66				

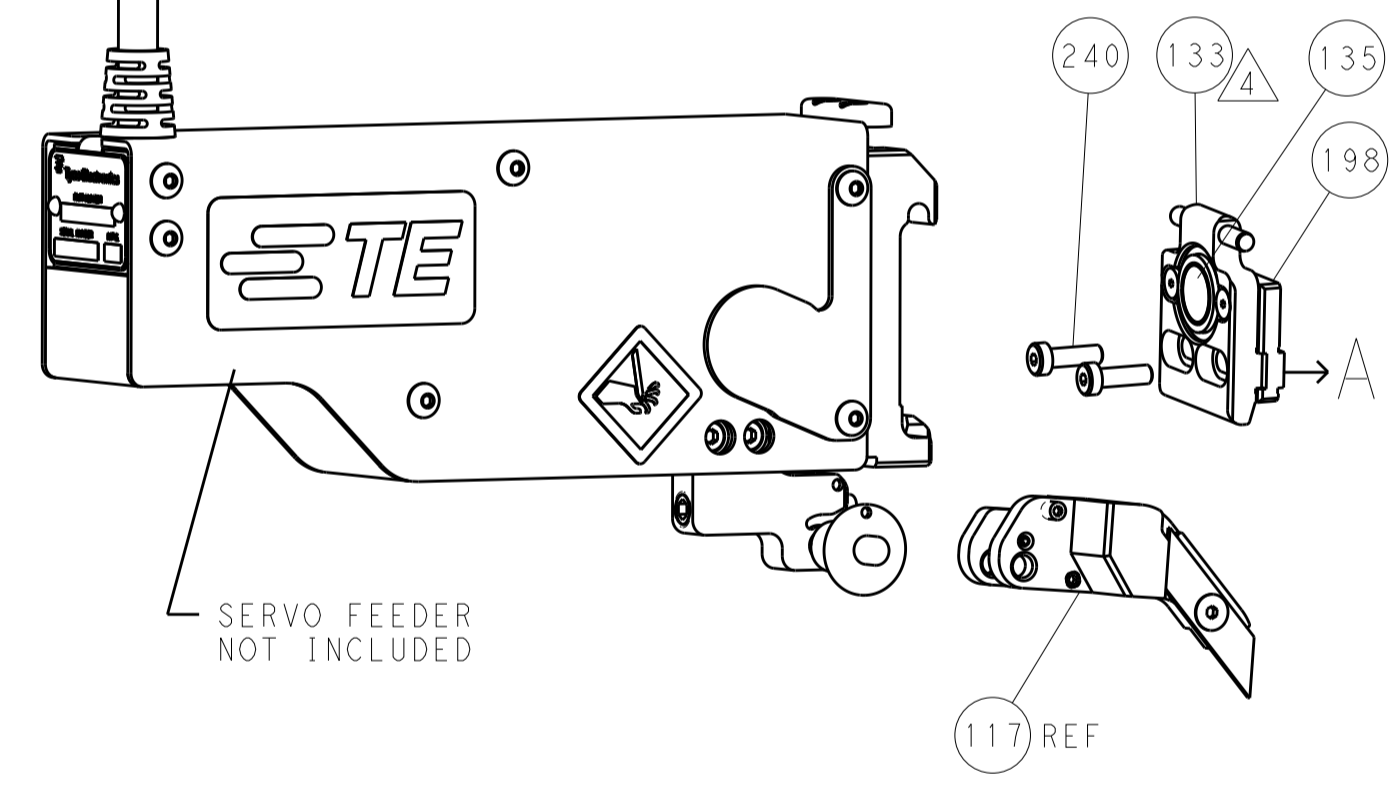
# FEED TYPE MECHANICAL



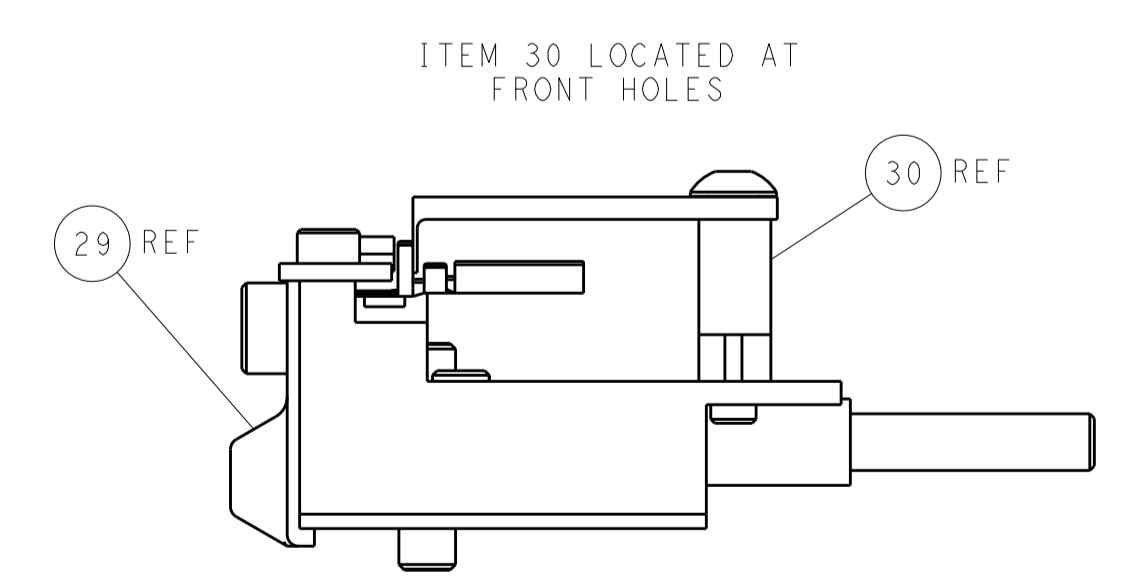
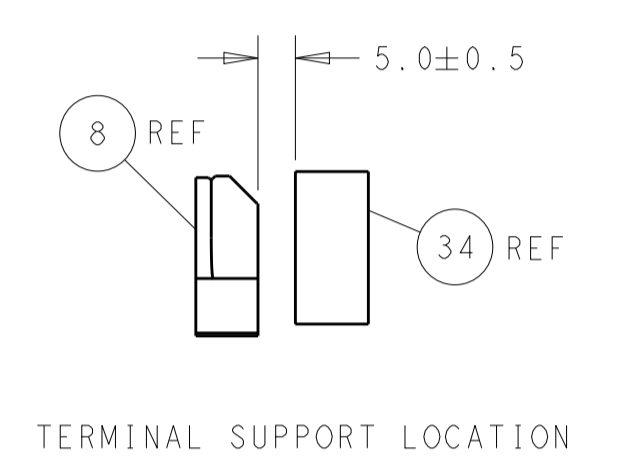
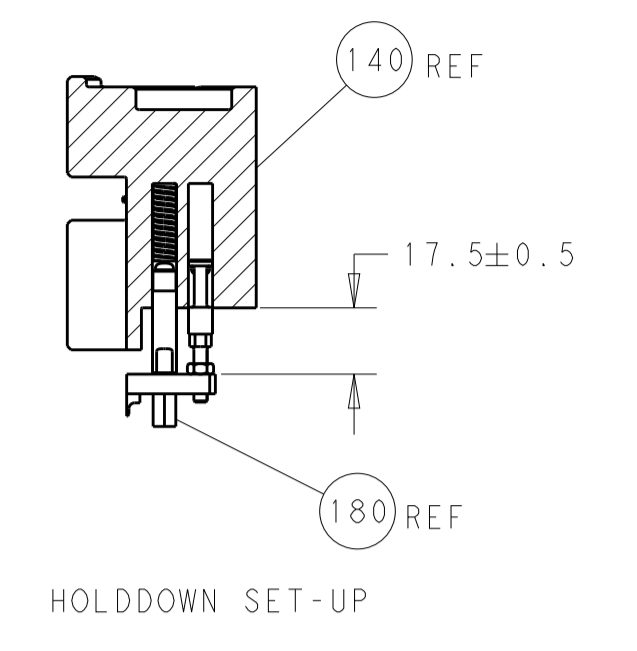
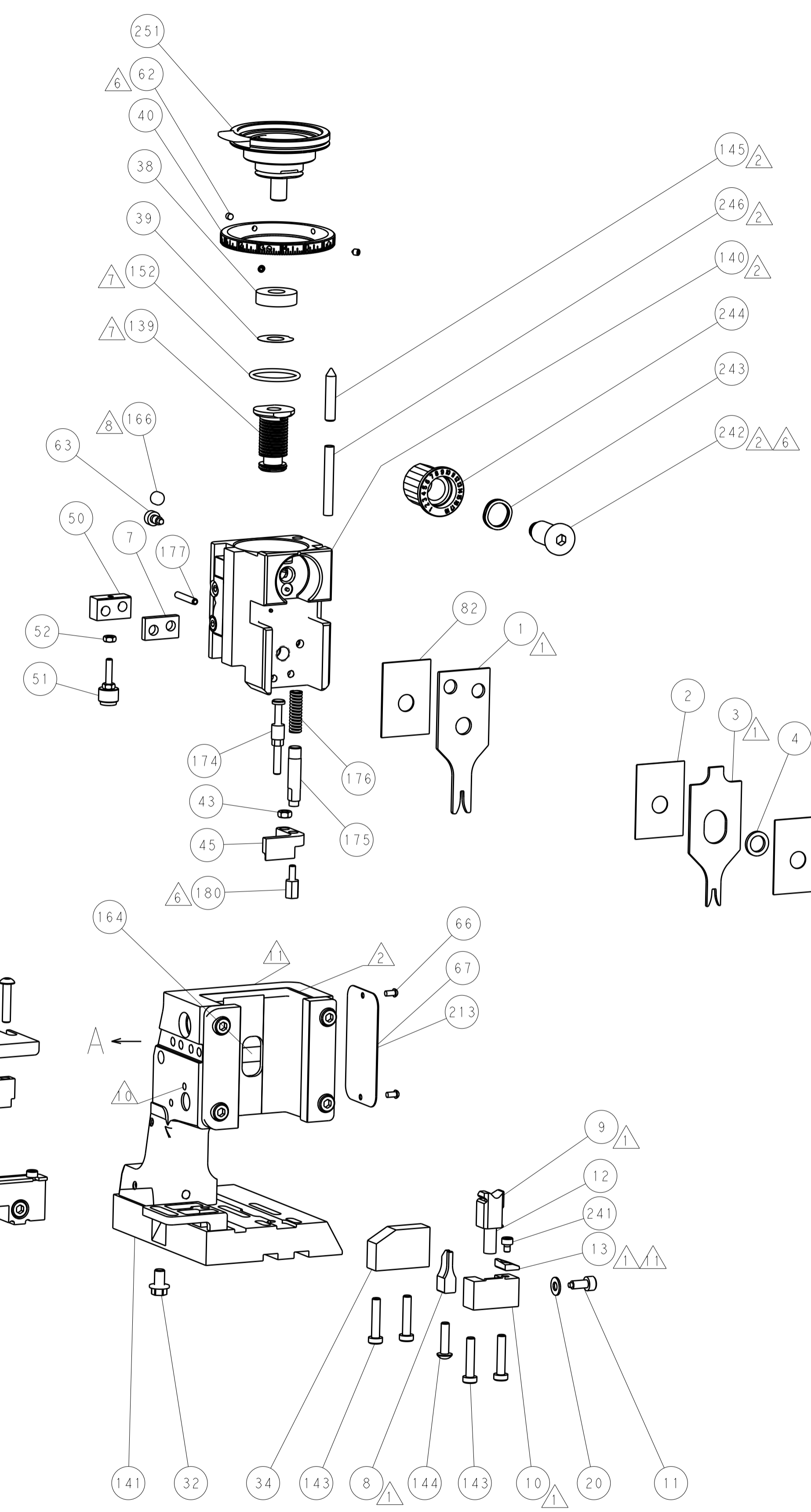
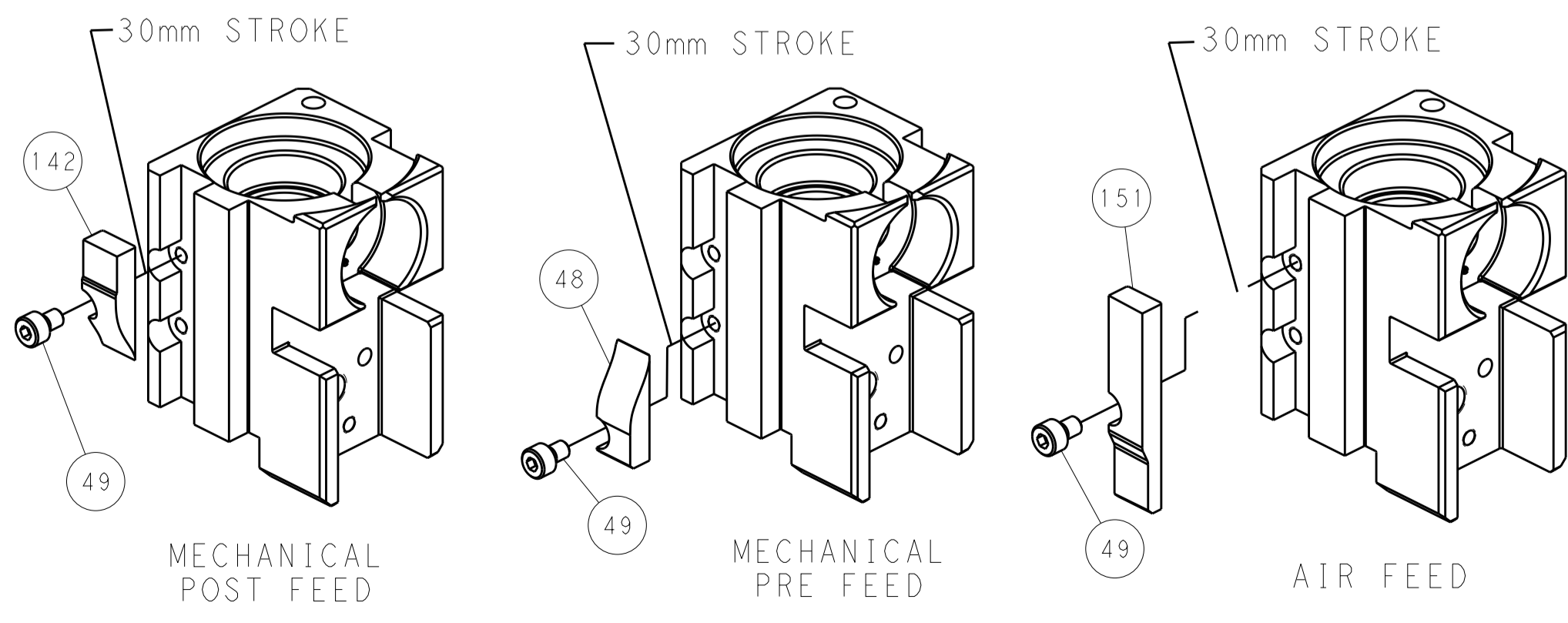
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN B. WEAVER 17DEC2014 CHK G. BAILEY 17DEC2014 APVD G. BAILEY 17DEC2014 PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2266604 SCALE 1:2 SHEET 4 OF 4 REV A1		RESTRICTED TO -	
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